

Work Order ID 142577

Thursday, March 10, 2016 10:48:48 AM

142577

Page 1

Item ID: D4977-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket, RH
Start Date: 3/14/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/1/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: ML5 Date: **MAR 10 2016** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4977	<u>PD 218</u>								

110	<u>16/03/10</u>	0.00				<u>4</u>			DAS 13 9-89
-----	-----------------	------	--	--	--	----------	--	--	-------------------

110
Outsource5
Outsource process - Machining
Memo
ISSUE P/O: 31700
POSSIBLE SUPPLIER: WEJAY

Certificate of conformaty required

115	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--

115
Packaging
Packaging
Memo
0.00
4X SP/6-05-19

117	QC6- Inspect dimensions to drawing	0.00							
-----	------------------------------------	------	--	--	--	--	--	--	--

117
QC
Quality Control
Memo
0.00
(4) DAS
38
9-89
MAY 19 2016



Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐							
OTHER :									

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : <u>32503</u> 1- Black Anodize as per Dwg 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	0.00 0.00				4		MAY 27 2016	DAS 13 9-89
130 *130* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00							4X SP/6-6-3
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(4)			DAS 38 9-89 JUN 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐					
Misidentified ☐	Past Due ☐						

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location QCK129	0.00							
180									
Packaging	Memo	0.00				4	DAG 6 9-89		
Packaging	***IDENTIFY BY STAMPING P# AND REV***								JUN 06 2016
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.01							
Quality Control									MLJ JUN 07 2016

MLJ JUN 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect, ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Thursday, March 10, 2016 10:48:52 AM

Page 1
4

Work Order ID: 142577

142577

Parent Item: D4977-2

D4977-2

Parent Item Name: Bracket, RH

Start Date: 3/14/2016

Required Date: 4/1/2016

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV: A NEW ISSUE JFS 13/11/22 VERIFY BY: JLM IPP
REV:B 14.06.16 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4977-2P		Purchased	No				Each	0.0000		4			
D4977-2P									**				
Bracket, RH													
M7075T6B4.000X03.00		Purchased	No				f	18.4000		0.964211			
0													
M7075T6B4 000X03 000									**				
7075-T6 BAR 4.000' X 3.000"													

Location	Loc Qty	Loc Code
MAT006	18.4	
M125584	0.9	
M130938	11.5	
→ M133426	6	

Handwritten: 4X 8p/6-05-19.
9.65 16/03/11

DQA: _____ Date: _____

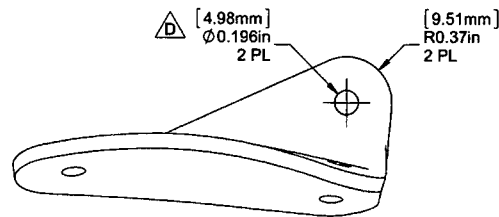
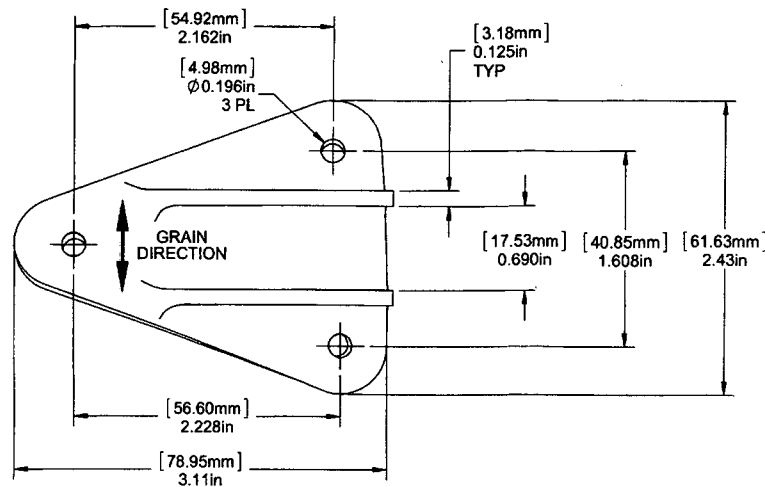


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								



D4977-1 BRACKET, LH

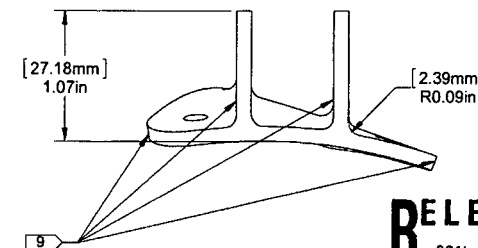
NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4977-1", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.09 lbs (0.04 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4977-1.d.IGES
- 9) IT IS ACCEPTABLE FOR THESE EDGES TO BE PARALLEL WITH EACH OTHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 142577 MLO

1603-10



RELEASED
2014-07-28

D	REVISED CLEVIS HOLE DIMENSIONS FROM Ø0.191 to Ø0.196 (ZN B6-1, ZN B5-2)	AK	14.07.14
C	REVISE NOTE 6) ZN (A8-1, A8-2)	AK	14.08.05
B	MODIFIED BRACKET GEOMETRY	AK	14.05.02
A	NEW ISSUE	DC	13.11.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4977	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

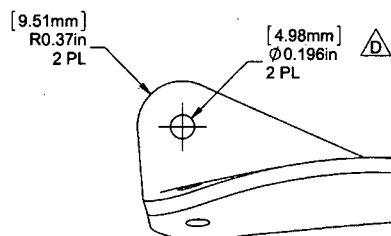
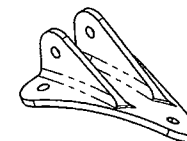
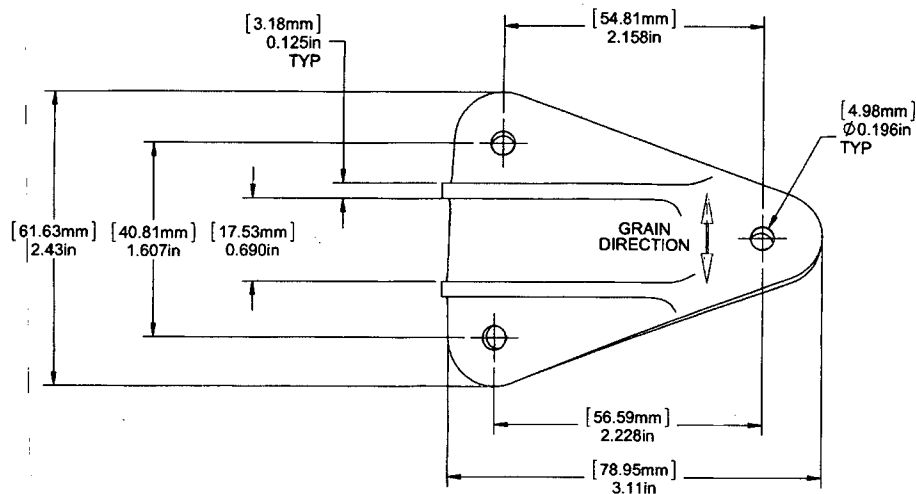
QA Closed: _____ Date: _____

Work Order update only ☐

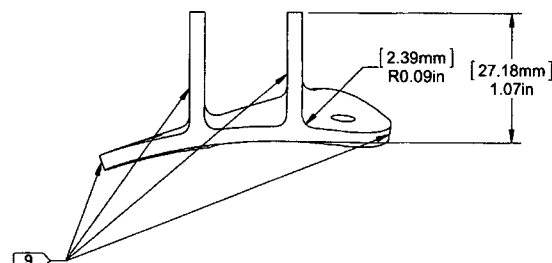
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
																								☐ OTHER : _____																																							

8 7 6 5 4 3 2 1



D4977-2 BRACKET, RH



NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4977-2", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.09 lbs (0.04 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4977-2.d.IGES
- 9) IT IS ACCEPTABLE FOR THESE EDGES TO BE PARALLEL WITH EACH OTHER

RELEASED
2014-07-28

APPROVED	DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AK		
	CHECKED	RF	DRAWING NO.	REV. D
	MFG. APPR.	JFS	D4977	SHEET 2 OF 2
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BRACKET	NTS
DATE 14.07.14			COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31700

Purchase Order Date 3/15/2016

PO Print Date 3/15/2016

Page Number 1 of 2

Order From :

VC-WMP001

Ship To : DART AEROSPACE LTD

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

MAR 15 2016

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: Journey Freight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3885-1P AS PER DWG D3885 REV. C B142573	Standard Web	5/5/2016 Yes 5/5/2016		25.00 Each	\$495.00	\$12,375.00
Line Total:							\$12,375.00
2	D4977-2P AS PER DWG D4977 REV. D B142577	Bracket, RH	5/5/2016 Yes 5/5/2016	FN	4.00 Each	\$425.00	\$1,700.00
Line Total:							\$1,700.00

PO Instructions: QUOTATION NO: WJ-8922

Note:

3/15/2016



Packing Slip 37901
600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

S
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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO.		DATE ORDERED		SHIPPED VIA	
		31700		03/16/16		Best way	
CUSTOMER CODE		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
DART							
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
25	0	25	Standard web as per drawig D3885 Rev. C D3885-1P B142573				
4	0	4	Bracket, right hand, as per drawing D4977, Rev. D D4977-2P ✓ B142577 <i>Sp/6-05-191</i>				
			Required by: May ¹⁸ 2016				
			RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.				
			G.S.T.				
			P.S.T.				
Inspection Supervisor <i>[Signature]</i>			ORDER: COMPLETE ☐ PARTIAL ☐			TOTAL	

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: May 12, 2016	
		P.O.# PO21700	
		WEJAY JOB# 37901	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4977-2P 'Bracket , Right Hand' B142577	4	Machined complete per drawing req'ts.	D4977 rev. D
Note: 1) Material: 7075 Aluminum supplied by Dart Aerospace ref# M133426. 2) Inspection/ Test Reports attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith
Authorized Q.A. Signatory



Customer Dart Aerospace Ltd. Customer P.O. PO31700
 Drawing # D4977 Drawing rev D
 Part Number D4977-2P E.C.O. -
 Part Name Bracket, Right Hand Material Aluminum Alloy 7075-T651
 Serial # 004 Inspected by Cliff Smith
 Job # 37901 Signature:



Overall Result

All Characteristics: 18
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: 1) Material supplied by DAS: 7075-T651
 per ASTM B209-10 ref. # M133426

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<- ->
■ 1a 1_B6	D	0.1968	0.1960	0.0050	-0.0010	0.0008	-
■ 1b 1_B6	D	0.1966	0.1960	0.0050	-0.0010	0.0006	-
■ 2 1_D7	CartDist	0.6888	0.6900	0.0100	-0.0100	-0.0012	-
■ 3a 1_B7	R	0.3741	0.3700	0.0300	-0.0300	0.0041	-
■ 3b 1_B7	R	0.3741	0.3700	0.0300	-0.0300	0.0041	-
■ 4 1_C5_X	Dist	3.1042	3.1100	0.0300	-0.0300	-0.0058	-
■ 5 1_D8_Y	Dist	2.4206	2.4300	0.0300	-0.0300	-0.0094	-
■ 6a 1_D4	D	0.1973	0.1960	0.0050	-0.0010	0.0013	-
■ 6b 1_D4	D	0.1974	0.1960	0.0050	-0.0010	0.0014	-
■ 6c 1_D4	D	0.1971	0.1960	0.0050	-0.0010	0.0011	-
■ 7 1_D6_X	Dist	2.1669	2.1580	0.0100	-0.0100	0.0089	-
■ 8 1_C6_X	Dist	2.2245	2.2280	0.0100	-0.0100	-0.0035	-
■ 9 1_D4_Y	Dist	1.6030	1.6070	0.0100	-0.0100	-0.0040	-
■ 10a 1_D7	CartDist	0.1262	0.1250	0.0100	-0.0100	0.0012	-
■ 10b 1_D7	CartDist	0.1262	0.1250	0.0100	-0.0100	0.0012	-
■ 11 1_B2	CartDist	1.0566	1.0700	0.0300	-0.0300	-0.0134	-

Manually Inspected Features

12 1_B2 R0.09 typ. -0.094 R TYP.
 13 1_A8 Deburring .005 to .010 max. PASSED



Customer Dart Aerospace Ltd. Customer P.O. PO31700

Drawing # D4977 Drawing rev D

Part Number D4977-2P E.C.O. -

Part Name Bracket, Right Hand Material Aluminum Alloy 7075-T651

Serial # 003 Inspected by Cliff Smith

Job # 37901 Signature:



Overall Result

All Characteristics: 18
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: 1) Material supplied by DAS: 7075-T651
 per ASTM B209-10 ref. # M133426

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<- >
1a 1_B6	D	0.1963	0.1960	0.0050	-0.0010	0.0003	-
1b 1_B6	D	0.1950	0.1960	0.0050	-0.0010	-0.0010	-
2 1_D7	CartDist	0.6890	0.6900	0.0100	-0.0100	-0.0010	-
3a 1_B7	R	0.3740	0.3700	0.0300	-0.0300	0.0040	-
3b 1_B7	R	0.3729	0.3700	0.0300	-0.0300	0.0029	-
4 1_C5_X	Dist	3.1033	3.1100	0.0300	-0.0300	-0.0067	-
5 1_D8_Y	Dist	2.4207	2.4300	0.0300	-0.0300	-0.0093	-
6a 1_D4	D	0.1970	0.1960	0.0050	-0.0010	0.0010	-
6b 1_D4	D	0.1973	0.1960	0.0050	-0.0010	0.0013	-
6c 1_D4	D	0.1971	0.1960	0.0050	-0.0010	0.0011	-
7 1_D6_X	Dist	2.1671	2.1580	0.0100	-0.0100	0.0091	-
8 1_C6_X	Dist	2.2245	2.2280	0.0100	-0.0100	-0.0035	-
9 1_D4_Y	Dist	1.6031	1.6070	0.0100	-0.0100	-0.0039	-
10a 1_D7	CartDist	0.1260	0.1250	0.0100	-0.0100	0.0010	-
10b 1_D7	CartDist	0.1260	0.1250	0.0100	-0.0100	0.0010	-
11 1_B2	CartDist	1.0564	1.0700	0.0300	-0.0300	-0.0136	-

Manually Inspected Features

12 1_B2 R0.09 typ. .094 R TYP.
 13 1_A8 Deburring .005 to .010 max. PASSED



Customer Dart Aerospace Ltd. Customer P.O. PO31700

Drawing # D4977 Drawing rev D

Part Number D4977-2P E.C.O. -

Part Name Bracket, Right Hand Material Aluminum Alloy 7075-T651

Serial # 002 Inspected by Cliff Smith

Job # 37901 Signature:



ACCEPTED

ZEISS



Overall Result

All Characteristics: 18
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: 1) Material supplied by DAS: 7075-T651
 per ASTM B209-10 ref. # M133426

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<- ->
■ 1a 1_B6	D	0.1967	0.1960	0.0050	-0.0010	0.0007	-
■ 1b 1_B6	D	0.1965	0.1960	0.0050	-0.0010	0.0005	-
■ 2 1_D7	CartDist	0.6886	0.6900	0.0100	-0.0100	-0.0014	-
■ 3a 1_B7	R	0.3731	0.3700	0.0300	-0.0300	0.0031	-
■ 3b 1_B7	R	0.3742	0.3700	0.0300	-0.0300	0.0042	-
■ 4 1_C5_X	Dist	3.1006	3.1100	0.0300	-0.0300	-0.0094	-
■ 5 1_D8_Y	Dist	2.4213	2.4300	0.0300	-0.0300	-0.0087	-
■ 6a 1_D4	D	0.1971	0.1960	0.0050	-0.0010	0.0011	-
■ 6b 1_D4	D	0.1972	0.1960	0.0050	-0.0010	0.0012	-
■ 6c 1_D4	D	0.1969	0.1960	0.0050	-0.0010	0.0009	-
■ 7 1_D6_X	Dist	2.1661	2.1580	0.0100	-0.0100	0.0081	-
■ 8 1_C6_X	Dist	2.2256	2.2280	0.0100	-0.0100	-0.0024	-
■ 9 1_D4_Y	Dist	1.6031	1.6070	0.0100	-0.0100	-0.0039	-
■ 10a 1_D7	CartDist	0.1265	0.1250	0.0100	-0.0100	0.0015	-
■ 10b 1_D7	CartDist	0.1265	0.1250	0.0100	-0.0100	0.0015	-
■ 11 1_B2	CartDist	1.0565	1.0700	0.0300	-0.0300	-0.0135	-

Manually Inspected Features

12 1_B2 R0.09 typ.
 13 1_A8 Deburring .005 to .010 max.

.094 R TYP.
PASSED



Customer Dart Aerospace Ltd. Customer P.O. PO31700
 Drawing # D4977 Drawing rev D
 Part Number D4977-2P E.C.O. --
 Part Name Bracket, Right Hand Material Aluminum Alloy 7075-T651
 Serial # 001 Inspected by Cliff Smith
 Job # 37901 Signature:



Overall Result

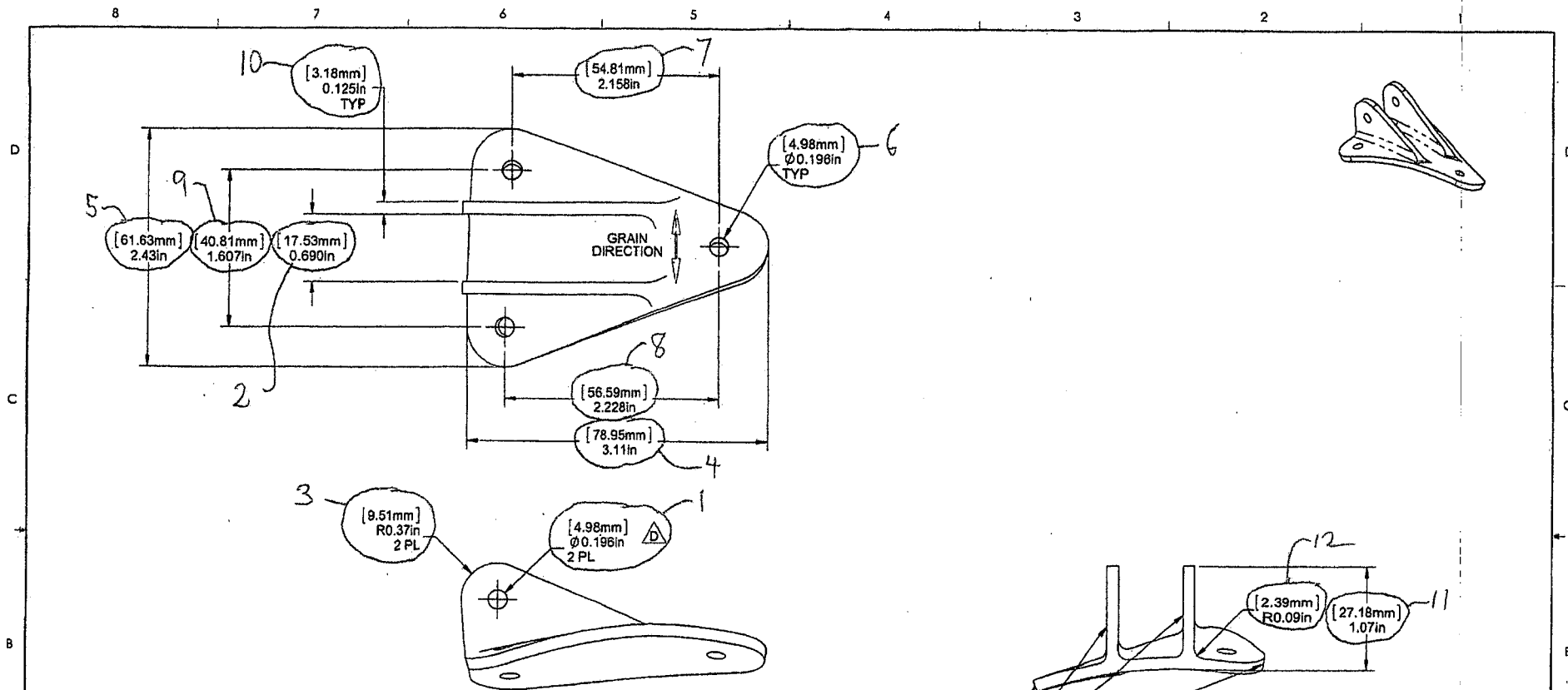
All Characteristics: 18
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: 1) Material supplied by DAS: 7075-T651
 per ASTM B209-10 ref. # M133426

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<-- -->
1a 1_B6	D	0.1973	0.1960	0.0050	-0.0010	0.0013	-
1b 1_B6	D	0.1964	0.1960	0.0050	-0.0010	0.0004	-
2 1_D7	CartDist	0.6894	0.6900	0.0100	-0.0100	-0.0006	-
3a 1_B7	R	0.3742	0.3700	0.0300	-0.0300	0.0042	-
3b 1_B7	R	0.3744	0.3700	0.0300	-0.0300	0.0044	-
4 1_C5_X	Dist	3.1044	3.1100	0.0300	-0.0300	-0.0056	-
5 1_D8_Y	Dist	2.4200	2.4300	0.0300	-0.0300	-0.0100	-
6a 1_D4	D	0.1966	0.1960	0.0050	-0.0010	0.0006	-
6b 1_D4	D	0.1974	0.1960	0.0050	-0.0010	0.0014	-
6c 1_D4	D	0.1967	0.1960	0.0050	-0.0010	0.0007	-
7 1_D6_X	Dist	2.1660	2.1580	0.0100	-0.0100	0.0080	-
8 1_C6_X	Dist	2.2250	2.2280	0.0100	-0.0100	-0.0030	-
9 1_D4_Y	Dist	1.6036	1.6070	0.0100	-0.0100	-0.0034	-
10a 1_D7	CartDist	0.1253	0.1250	0.0100	-0.0100	0.0003	-
10b 1_D7	CartDist	0.1252	0.1250	0.0100	-0.0100	0.0002	-
11 1_B2	CartDist	1.0561	1.0700	0.0300	-0.0300	-0.0139	-

Manually Inspected Features

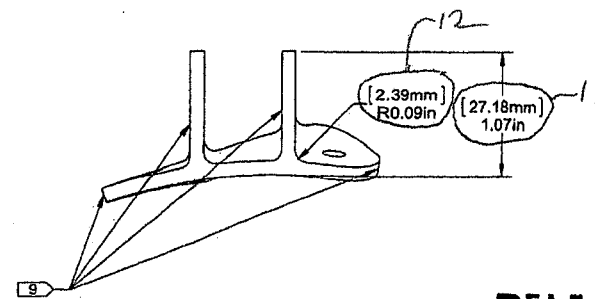
12 1_B2 R0.09 typ. .094 R TYP.
 13 1_A8 Deburring .005 to .010 max. PASSED



D4977-2 BRACKET, RH

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4977-2", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.09 lbs (0.04 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4977-2.d.JGES
- 9) IT IS ACCEPTABLE FOR THESE EDGES TO BE PARALLEL WITH EACH OTHER



RELEASED
R 2014-07-28

APPROVED

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4977	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32503**

Purchase Order Date 5/27/2016

PO Print Date 5/31/2016

Page Number 2 of 3

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

VENDOR'S TRUCK

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

3	142633	646.3312 CENTER PLATE REV. N/C	6/2/2016	12.00	\$12.05	\$144.60
Yes						
6/2/2016						
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N						

Line Total: \$144.60

4	142487	646.9710 BODY REV. C	6/2/2016	15.00	\$14.50	\$217.50
Yes						
6/2/2016						
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N						

Line Total: \$217.50

5	142577	D4977-2 BRACKET REV. D	6/2/2016	4.00	\$8.55	\$34.20
Yes						
6/2/2016						
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N						

Line Total: \$34.20

Note:

5/31/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911787

Date: 03-Jun-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.			
5 ea	Part: D5155-9 CO-PILOT CO-PILOT Job: 19571	Rev: B PO: 32503	Line: 1
10 ea	Part: SUPPORT Job: 19572	Rev: N/C PO: 32503	Line: 2
12 ea	Part: 646.3312 CENTER PLATE Job: 19573	Rev: N/C PO: 32503	Line: 3
15 ea	Part: 646.9710 BODY Job: 19574	Rev: C PO: 32503	Line: 4
4 ea	Part: D4977-2 BRACKET Job: 19575	Rev: D PO: 32503	Line: 5
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 19576	Rev: PO: 32503	Line: 7
DATE: <u>3/6/16</u> CERTIFIED SIGNATURE: <u>[Signature]</u> RECEIVER SIGNATURE: _____ Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

SP/6-6-2



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911787

Date: 03-Jun-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
Quantity	Description	
	CERTIFICATE OF CONFORMANCE	
	A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.	
	MADE IN CANADA.	
	<i>SP16-06-3</i>	